

# ENGINEERING CHANGE NOTICE

## DART AEROSPACE LTD

Date:	20.02.25	Job No.:	Sustaining Red Barn (Sikorsky)	ADR Yes/No:	N	ADR Date:		ECN #:	20- 527
Product No.:	RB 92700-10350-041	Created By:	KPT	Approved By:					
Product Name:	Seal Remover Set	Checked By:	SAJ						

### Reason for Change:

Service Bulletin from Sikorsky specifies correct hardware to be used.

### Documents Released:

RB 92700-10350-041 REV. *B mnd*

IF APPLICABLE: NCR: \_\_\_\_\_ PAR: \_\_\_\_\_ CAR: \_\_\_\_\_ CIR: \_\_\_\_\_ URF: \_\_\_\_\_

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☒

PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MG		<i>mnd 20.03.02</i>
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MG		<i>mnd 20.03.02</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MG		<i>mnd 20.03.02</i>
17	Update / Verify Authorized Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N	MG		
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	Y	MG	<i>Sent to Anzutech</i>	<i>mnd 20.03.02</i>
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

### Description / Action:

Release RB 92700-10350-041 REV. B

Place RB 92700-10350-041 REV. A in superseded folder

Material for RB 92700-10350-041-8 and RB 92700-10350-041-9 must comply with REV. B

RB 92700-10350-041-5 Seal Remover Assy must comply with REV. B

-8

R208275

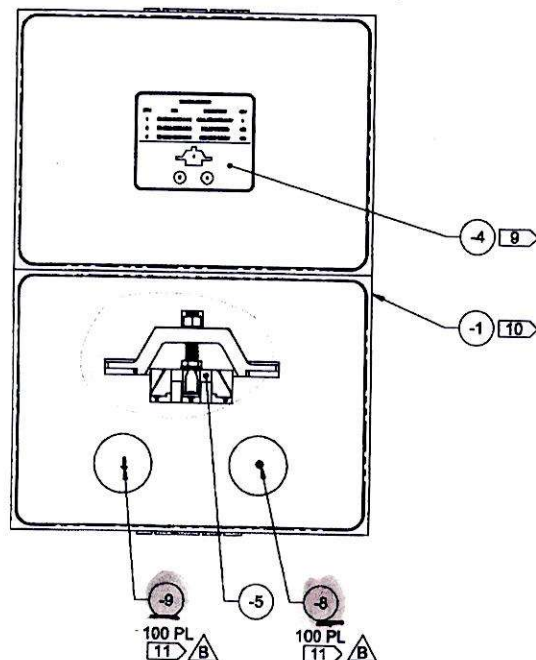
Rework done *JK*

3-13-20 parts scrapped.

ECN Verified & Complete: \_\_\_\_\_

Date: \_\_\_\_\_

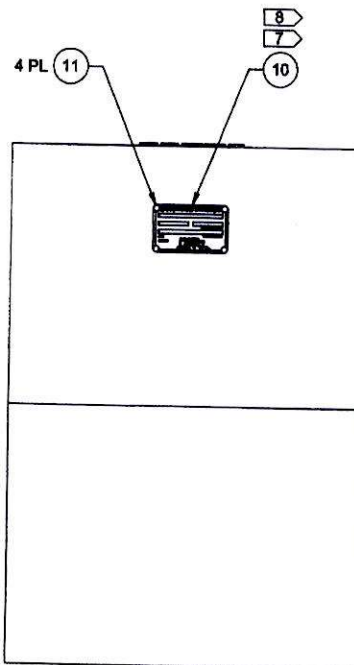
ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10350-041-1	PACKAGING ASSY
-4	1	RB 92700-10350-041-4	CONTENT PLACARD
-5	1	RB 92700-10350-041-5	SEAL REMOVER ASSY
-8	100	RB 92700-10350-041-8	SELF RETAINING WASHER 0.102" ID. X 0.285" OD. NYLON PLASTIC
-9	100	RB 92700-10350-041-9	HEX HEAD ZINC-PLATED STEEL SCREW #4-40 X 3/8" LG
10	1	RB41011	DART PLACARD
11	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.



RB 92700-10350-041 SEAL REMOVER SET

NOTES:

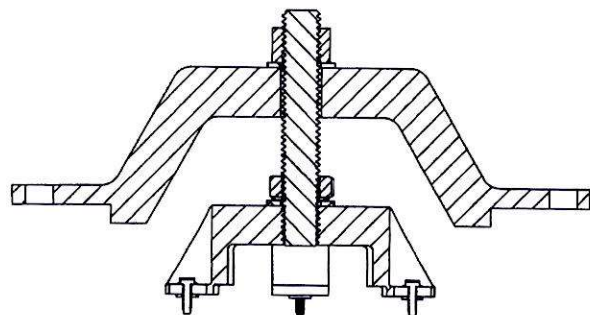
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
- 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE
- 11) HARDWARE MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



B	UPDATE HARDWARE LIST, REASON SB FROM SIKORSKY	20-527	SAD
A	NEW ISSUE	18-642	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RB 92700-10350-041	SHEET 1 OF 10
APPROVED	N/O	TITLE	SCALE
DATE 2/27/2020		SEAL REMOVER SET	NTS
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ITEM #	QTY	PART #	PART TITLE
-6	1	RB 92700-10350-041-6	SEAL REMOVER
-7	1	RB 92700-10350-041-7	SEAL REMOVER BASE
13	1	McMaster#98758A516 OR EQUIV.	STEEL THREADED ROD 1/2"-13 x 3-1/2", L.G.
14	4	McMaster#91755A206 OR EQUIV.	SELF RETAINING WASHER 0.102" ID. X 0.265" OD. NYLON PLASTIC
15	1	McMaster#94895A823 OR EQUIV.	STEEL GRADE 8 HEX NUT 1/2"-13
16	1	CL-8-HN OR EQUIV.	BLACK OXIDE STEEL HEX NUT 1/2"-13
17	4	McMaster#90096A108 OR EQUIV.	HEX HEAD ZINC-PLATED STEEL SCREW #4-40 X 3/8" L.G.
18	2	NAS1149F0863P	CAD. PLATED STEEL WASHER 0.515" ID X 0.875" OD. X 0.063" THK.



RB 92700-10350-041-5 SEAL REMOVER ASSY

11

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X =  $\pm 0.1"$  /  $\pm 1"$   
X.XX =  $\pm 0.01"$  /  $\pm 0.5"$   
X.XXX =  $\pm 0.005"$  /  $\pm 0.1"$   
X.XXXX =  $\pm 0.0005"$  /  $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: N/A

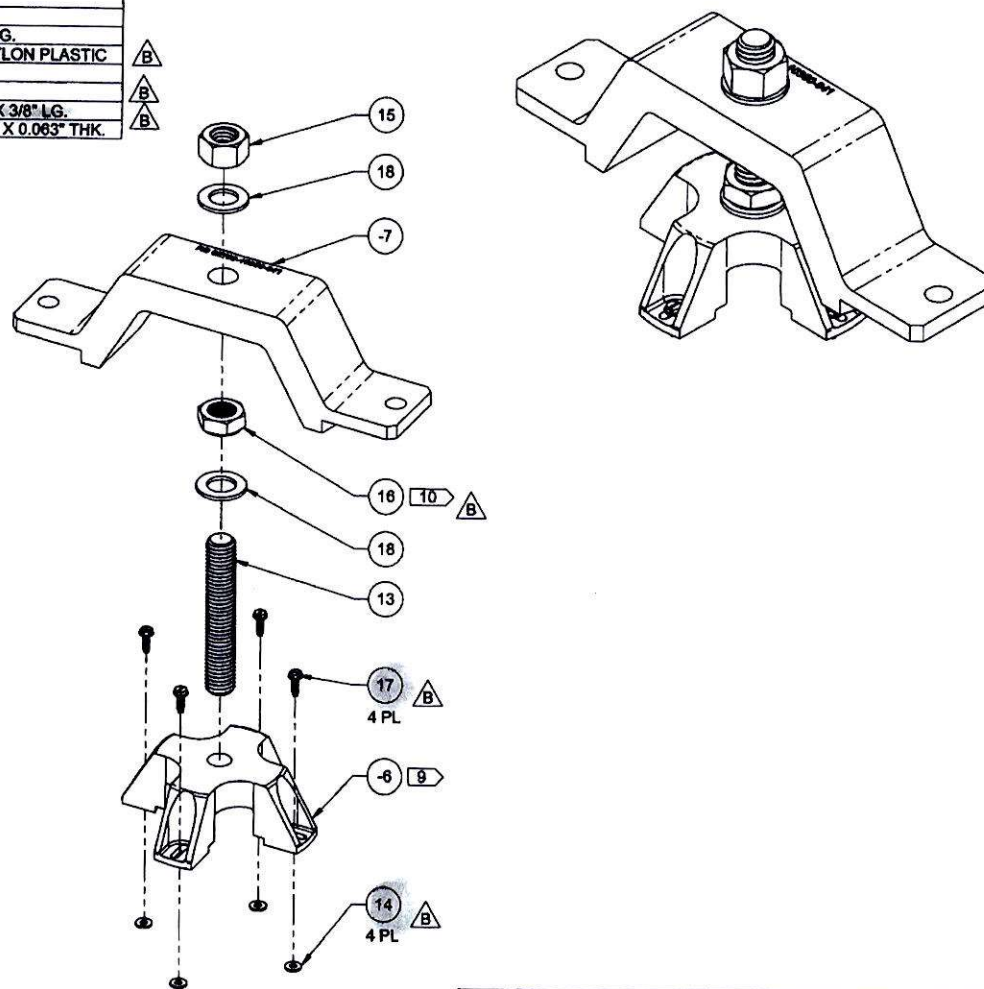
- 7) IDENTIFICATION: N/A

- 8) ASSEMBLE AS SHOWN

- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM -6 THEN ASSEMBLE WITH ITEM 13 AND REMOVE EXCESS

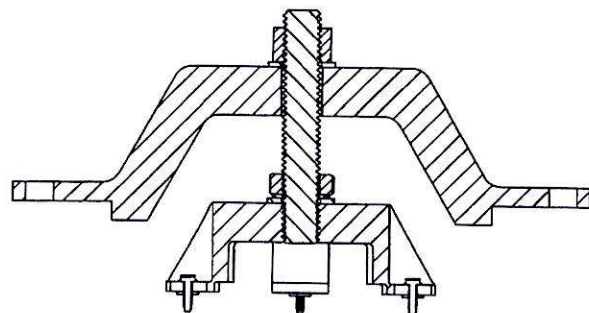
- 10) INSTALL ITEM 18 WITH A TORQUE OF 37-50 IN-LBS AS SHOWN

- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

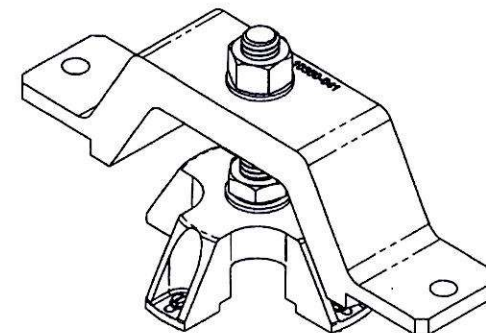
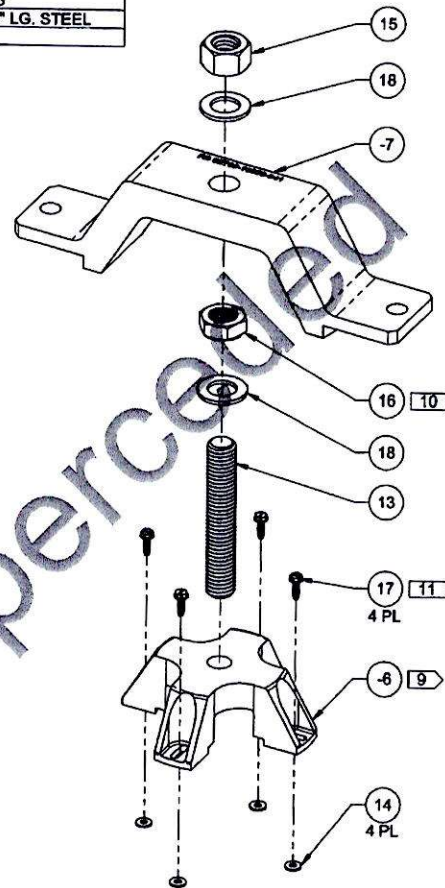


DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RB 92700-10350-041	SHEET 6 OF 10
APPROVED	10	TITLE	SCALE
		SEAL REMOVER SET	NTS
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ITEM #	QTY	PART #	PART TITLE
-6	1	RB 92700-10350-041-6	SEAL REMOVER
-7	1	RB 92700-10350-041-7	SEAL REMOVER BASE
13	1	McMaster#98758A516 OR EQUIV	STEEL THREADED ROD 1/2"-13 x 3-1/2" L.G.
14	4	McMaster#90295A362 OR EQUIV	WASHER 0.12" ID. X 0.28" OD. NYLON PLASTIC
15	1	McMaster#94895A823 OR EQUIV	STEEL GRADE 8 HEX NUT 1/2"-13
16	1	McMaster#94945A224 OR EQUIV	STEEL GRADE 8 THIN LOCKNUT 1/2"-13
17	4	McMaster#93882A108 OR EQUIV	HEX HEAD THREAD-FORMING SCREW #4-40 X 3/8" L.G. STEEL
18	2	NAS1149F0863P	WASHER



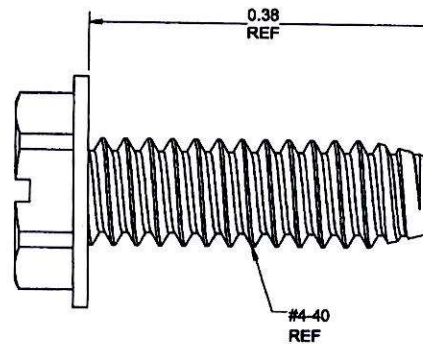
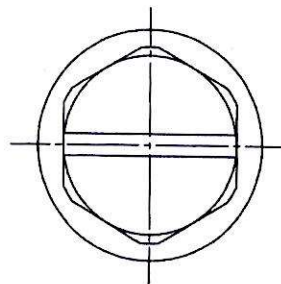
RB 92700-10350-041-5 SEAL REMOVER ASSY



# NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM -6 THEN ASSEMBLE WITH ITEM 13 AND REMOVE EXCESS
- 10) INSTALL ITEM 16 WITH A TORQUE OF 37-50 IN-LBS AS SHOWN
- 11) INSTALL ITEM 17 HAND TIGHT
- 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10350-041	SHEET 6 OF 10
APPROVED	VH	TITLE	SCALE
		SEAL REMOVER SET	NTS
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**RB 92700-10350-041-9 HEX HEAD ZINC-PLATED STEEL SCREW #4-40 X 3/8" LG.**

**B**

**NOTES:**

- 1) MATERIAL: McMaster#90098A108 OR EQUIV.
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1"  
 X.XX = +/- 0.01" / +/- 0.5"  
 X.XXX = +/- 0.005" / +/- 0.1"  
 X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

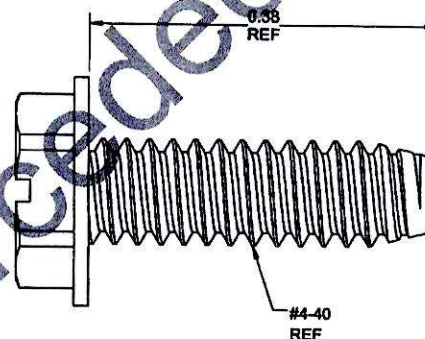
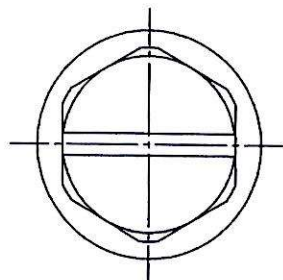
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RB 92700-10350-041	SHEET 10 OF 10
APPROVED	<i>AK</i>	TITLE	SCALE
DATE 2/27/2020		SEAL REMOVER SET	NTS
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**RB 92700-10350-041-9 STEEL HEX HEAD THREAD-FORMING SCREW #4-40 x 3/8" LG.**

**NOTES:**

1) MATERIAL: McMaster#93882A108 OR EQUIV

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°

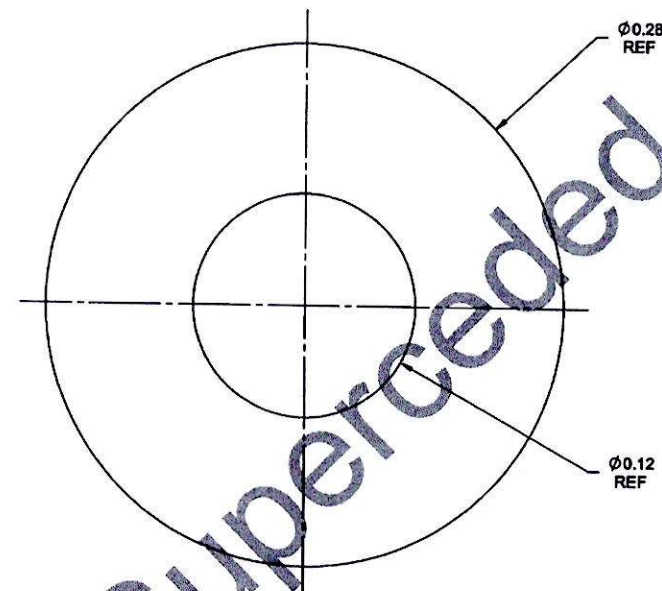
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10350-041	SHEET 10 OF 10
APPROVED	VH	TITLE	SCALE
DATE 9/6/2018		SEAL REMOVER SET	NTS
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RB 92700-10350-041-8 WHITE NYLON WASHER 0.12" ID x 0.28" OD.

**NOTES:**

1) MATERIAL: McMaster#90295A362 OR EQUIV

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X =  $\pm 0.1"$  /  $\pm 1"$   
 X.XX =  $\pm 0.01"$  /  $\pm 0.5"$   
 X.XXX =  $\pm 0.005"$  /  $\pm 0.1"$   
 X.XXXX =  $\pm 0.0005"$  /  $\pm 0.05"$

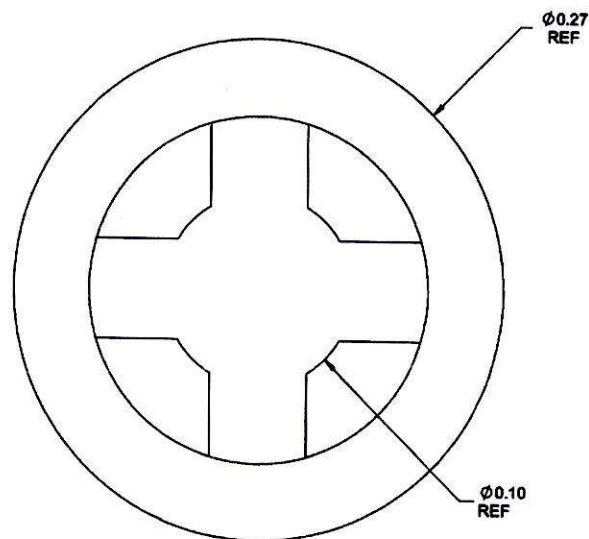
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10350-041	SHEET 9 OF 10
APPROVED	VT	TITLE	SCALE
		SEAL REMOVER SET	NTS
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**RB 92700-10350-041-8 SELF RETAINING WASHER 0.102" ID. X 0.265" OD. NYLON PLASTIC**

**NOTES:**

1) MATERIAL: McMaster #91755A205 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	FK	RB 92700-10350-041	SHEET 9 OF 10
APPROVED	/s/	TITLE	SCALE
DATE 2/27/2020		SEAL REMOVER SET	NTS
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